

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015626**Date Inspected:** 14-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder( OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector randomly observed the following work in progress:

**OBG # TRIAL ASSEMBLY YARD**

Segment # 9AW ~ 9BW

This QA inspector observed, ZPMC qualified welding personnel identified as 045196 perform Shielded Metal Arc Welding (SMAW), weld joint identified as EP111-001-014; The Critical Welding Repair Report (WRR) was B-CWR13942. ZPMC QC is identified as Mr. Shi Lei. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-4G (4F) FCM-Repair-1. See the below attached Photo.

Segment # 9CE ~ 9DE

This QA inspector observed, ZPMC qualified welding personnel identified as 066179 perform Shielded Metal Arc Welding (SMAW), weld joint identified as DP699-001-020; ZPMC QC is identified as Mr. Wang Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with

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WPS-B-T-3213-B-U3b.

Segment # 9CE~9DE

This QA inspector observed, ZPMC qualified welding personnel identified as 037932 perform Shielded Metal Arc Welding (SMAW), weld joint identified as CA063-005; ZPMC CWI is identified as Mr. Li Huajie. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2214-TC-U4b-FCM-1. See the attached photo.

Segment # 9CE ~9DE

This QA inspector observed, ZPMC qualified welding personnel identified as 067942 perform Flux Core Arc Welding (FCAW), weld joint identified as BP181-001-043; ZPMC QC is identified as Mr. Wang Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132.

Segment # 9BW

During random visual inspection this Caltrans Quality Assurance (QA) inspector observed that ZPMC personnel had performed Shielded Metal Arc Welding, ZPMC qualified welding personnel identified as 068097 Weld connection joint is Bottom plate to Side plate. The Critical Welding Repair Report (CWRR) was B-CWR1694. The base metal was gauged at 9BW Side plate SP160A-PL55A 80mm in length 30mm in wide 4mm in depth. ZPMC QC is identified as Mr. Shi Lei. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-4G (4F) FCM-Repair.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



## Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

## Comments

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This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Prabhune,Manoj	Quality Assurance Inspector
<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer

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